

Date: Monday, 2/27/2006 4:22:13 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 25999	
Estimate Number : 10534	
P.O. Number : NIA	Part Number : D2574
This Issue : 2/27/2006 S.O. No. : NIA	Drawing Number : D2574 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 25862	Material : NIA
	Due Date : 3/15/2006 Qty: 8 Um: Each
Written By : <u>See COMMENT Below</u>	
Checked & Approved By : <u>JA 06.02.28</u>	
Comment : Est Rev: I As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2574
 Ensure that grain is along 5.00" length
 Batch No: B24069 En 06/03/09 (B)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 25999 Double check by: MB

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2573 & D2574

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G 06/03/11 8
J.G 06/03/11 8
REFERENCE ONLY

Date: Monday, 2/27/2006 4:22:14 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 25999

Part Number: D2574

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 06.03.13 (8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FC 060314 (8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/03/14 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M 06 03 15 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STY80

Pu 4/3/16 (8)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/16 (8)

Job Completion



u 06.03.16

DART AEROSPACE LTD		Work Order:	25999
Description: Saddle, Aft Inboard		Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.751	1.751	1.750	1.749		
C	3.495	3.505		3.499	3.499	3.498	3.499		
D	1.745	1.755		1.751	1.750	1.749	1.749		
E	7.990	8.010		8.003	8.003	8.004	8.003		
F	0.490	0.510		0.501	0.501	0.502	0.503		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.501	0.501		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.568	0.569	0.568	0.568		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.372	1.372	1.372	1.371		
N	2.495	2.505		2.501	2.500	2.501	2.500		
O	4.119	4.129		4.122	4.122	4.123	4.124		
P	0.115	0.135		0.129	0.129	0.128	0.127		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.251	0.250	0.249	0.248		
S	0.115	0.135		0.130	0.129	0.128	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.220	3.220	3.221	3.220		
V	0.230	0.250		0.235	0.235	0.234	0.235		
W	0.115	0.135		0.130	0.131	0.130	0.129		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.362	0.361	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.627	0.626	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.250	0.249	0.248		
AE	1.500	1.520		1.508	1.513	1.514	1.514		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.255	0.254	0.255	0.255		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	J.G.
Date:	06/03/12

Audited by:	SD
Date:	06/03/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 25999
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.747	1.747	1.747	1.747		
C	3.495	3.505		3.500	3.500	3.501	3.502		
D	1.745	1.755		1.747	1.747	1.746	1.746		
E	7.990	8.010		8.002	8.003	8.003	8.003		
F	0.490	0.510		0.506	0.501	0.502	0.501		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.501	0.501	0.500	0.499		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.569	0.569	0.568	0.568		
L	1.174	1.184		1.177	1.177	1.177	1.176		
M	1.365	1.375		1.371	1.371	1.372	1.373		
N	2.495	2.505		2.498	2.499	2.498	2.498		
O	4.119	4.129		4.122	4.122	4.122	4.122		
P	0.115	0.135		0.131	0.132	0.130	0.130		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.254	0.253	0.251	0.252		
S	0.115	0.135		0.131	0.130	0.130	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.220	3.220	3.221	3.221		
V	0.230	0.250		0.234	0.233	0.234	0.231		
W	0.115	0.135		0.130	0.127	0.128	0.127		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.362	0.361	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.627	0.628	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.247	0.248	0.249		
AE	1.500	1.520		1.514	1.513	1.512	1.513		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.249	0.249	0.249		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by: 3.6
Date: 06/03/13

Audited by: SA
Date: 06-03-13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

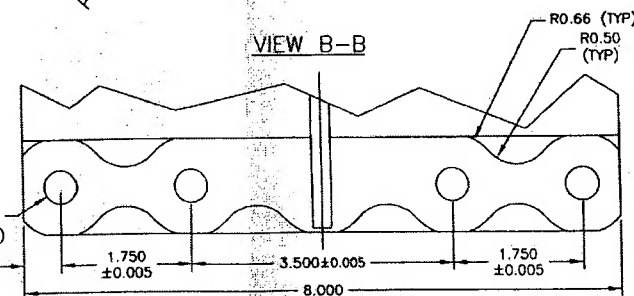
05.12.06

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

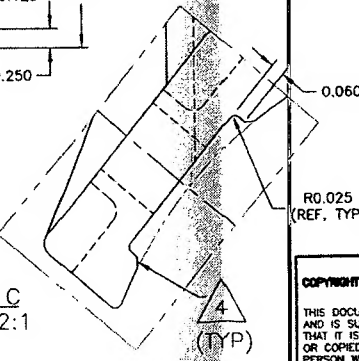
VIEW B-B



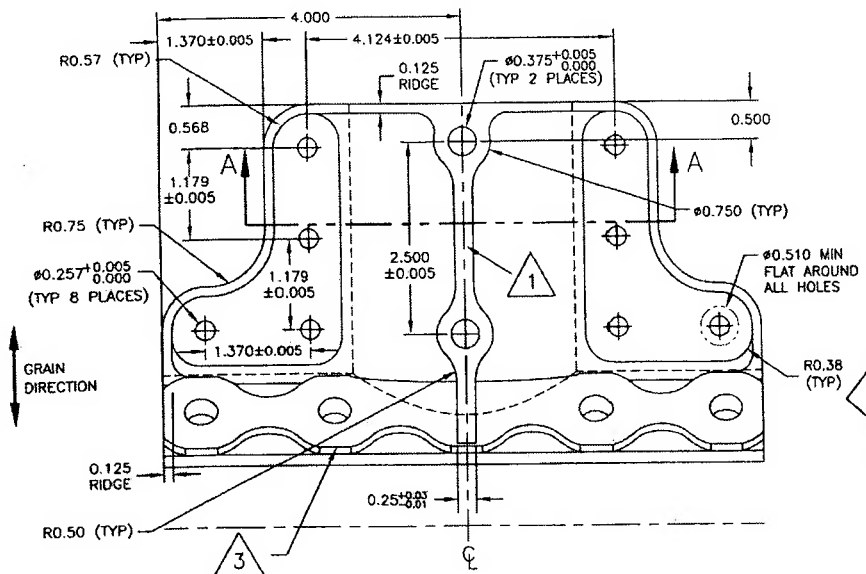
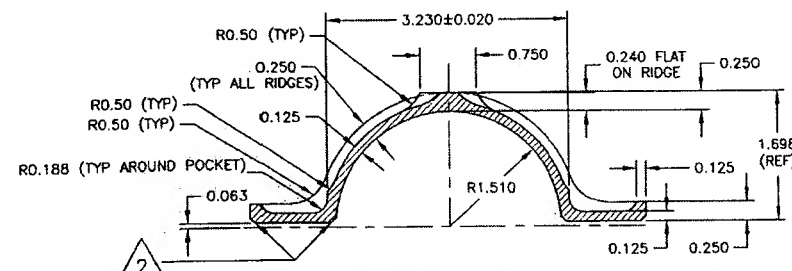
E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	05.07.13	DRAWING NO. D2574
		TITLE INNER AFT SADDLE
		SHEET 1 OF 1
		SCALE 2:3

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DART AEROSPACE LTD.

DETAIL C
SCALE 2:1



SECTION A-A



UNCONTROLLED COPY
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WITHOUT NOTICE
WORK ORDER NO. 25999
SHOP COPY
RETURN TO
ENGINEERING

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 26/03/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:22:13 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 25999	
Estimate Number : 10534	
P.O. Number :	Part Number : D2574
This Issue : 2/27/2006 S.O. No. :	Drawing Number : D2574 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 25862	Material :
Written By :	Due Date : 3/15/2006 Qty: 8 Um: Each
Checked & Approved By : <u>JA 06.02.28</u>	
Comment : Est Rev: I As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2574 *06.03.12*
 Ensure that grain is along 5.00" length
 Batch No: 324069 *En 06/03/09*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 25999 Double check by: MS

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2573 & D2574

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:22:14 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 25999

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 25999
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755							
C	3.495	3.505							
D	1.745	1.755							
E	7.990	8.010							
F	0.490	0.510							
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510							
J	1.174	1.184							
K	0.558	0.578							
L	1.174	1.184							
M	1.365	1.375							
N	2.495	2.505							
O	4.119	4.129							
P	0.115	0.135							
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260							
S	0.115	0.135							
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250							
V	0.230	0.250							
W	0.115	0.135							
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372							
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635							
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260							
AE	1.500	1.520							
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260							
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	
Date:	

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	25999
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
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C	3.495	3.505							
D	1.745	1.755							
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H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510							
J	1.174	1.184							
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L	1.174	1.184							
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S	0.115	0.135							
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250							
V	0.230	0.250							
W	0.115	0.135							
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372							
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635							
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260							
AE	1.500	1.520							
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260							
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

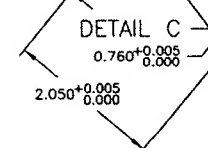
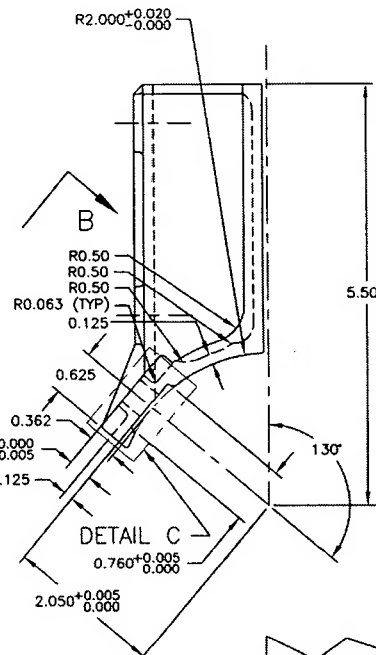
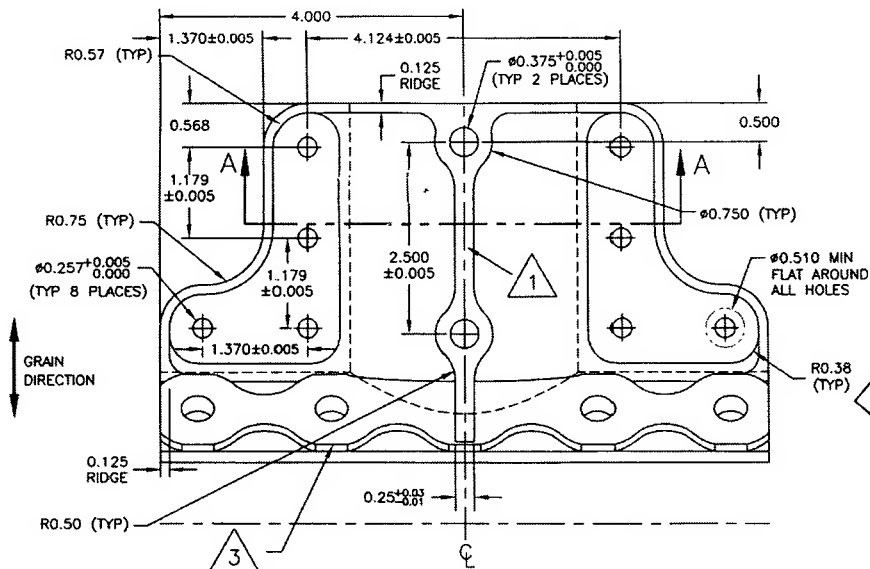
Measured by:	
Date:	

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06

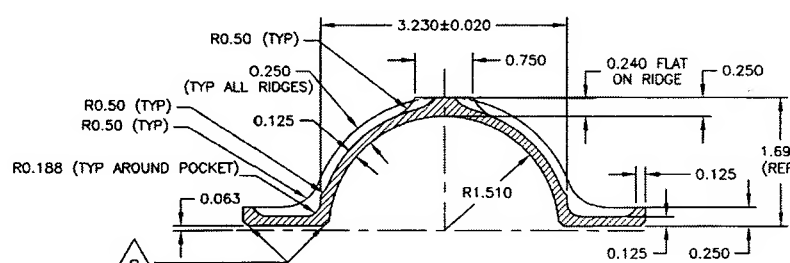
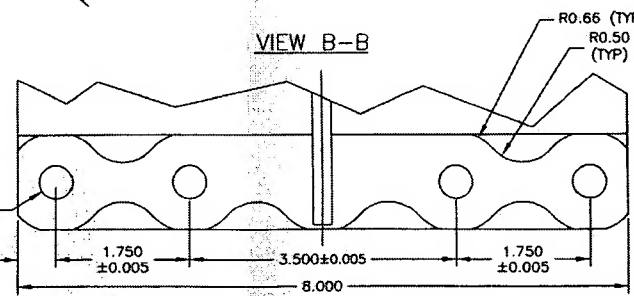


NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

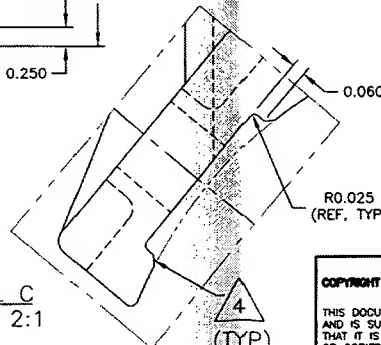
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)

VIEW B-B



SECTION A-A

DETAIL C
SCALE 2:1



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	05.07.13	DRAWING NO. D2574
TITLE	INNER AFT SADDLE	SCALE 2:3

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